

Date: Monday, 11/12/2007 11:46:20 AM
 User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HI-STEP LEG ASSEMBLY |
| Job Number : 35626 | |
| Estimate Number : 10385 | |
| P.O. Number : | Part Number : D3065041 |
| This Issue : 11/12/2007 S.O. No. : | Drawing Number : D3065 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : |
| Previous Run : 35622 | Material : |
| Written By : | Due Date : 12/23/2007 Qty: ⁵⁰ 100 Um: ² Each |
| Checked & Approved By : <u>[Signature]</u> 07.11.12 | |
| Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|-------------|
| 1.0 | D30651 | Step Spacer |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : ⁵⁰~~100.0000~~ Each(s)

Step Spacer

B 35614

CB08/05/06

| | | |
|-----|--------|-------------|
| 2.0 | D30653 | Step Spacer |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : ⁵⁰~~100.0000~~ Each(s)

Step Spacer

B 35615

CB08/05/06

| | | |
|-----|--------|----------|
| 3.0 | D30655 | Step Leg |
|-----|--------|----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : ¹⁰⁰~~200.0000~~ Each(s)

Step Leg

B 38262 (74)

35621 (49x) CB08/05/06

| | | |
|-----|--------|-------------|
| 4.0 | D30657 | Step Spacer |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : ⁵⁰~~100.0000~~ Each(s)

Step Spacer

B 35616 (49x)

B37771 (H)

CB08/05/06

| | | |
|-----|--------------|-----------------------|
| 5.0 | MS20470AD44. | Rivet, Universal Head |
|-----|--------------|-----------------------|



Comment: Qty.: 30.0000 Each(s)/Unit Total : ¹⁵⁰⁰~~3000.0000~~ Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

30 MS20470AD4-4

Description

Rivet

Batch

M106552

CB08/05/06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/12/2007 11:46:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 35626

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Pto

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

CB 08/05/06 (50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



08/05/06 (x50)

Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A 19.18

08-06-06 50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion


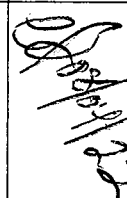
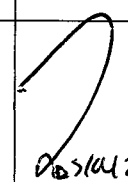



mf 08-05-06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3065-041 PAR #: N/A Fault Category: Prod / Prod Ass' Made Small NCR: Yes No DQA: D Date: 08/05/09
 QA: N/C Closed: D Date: 08/05/10

| NCR: <u>35626</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|--|---------------------------------|--|---------------------------|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/04/22 | 6 | 1 piece D3067-7 was scrap. 1 hole was too big when led too remind rivet training training human error. |  08/04/22 | Scrap + destroy replace |  08/05/06 | SN 08/05/06 |  08/04/22 |  08/05/06 |
| | | | | | | | | |
| | | | | | | | | |

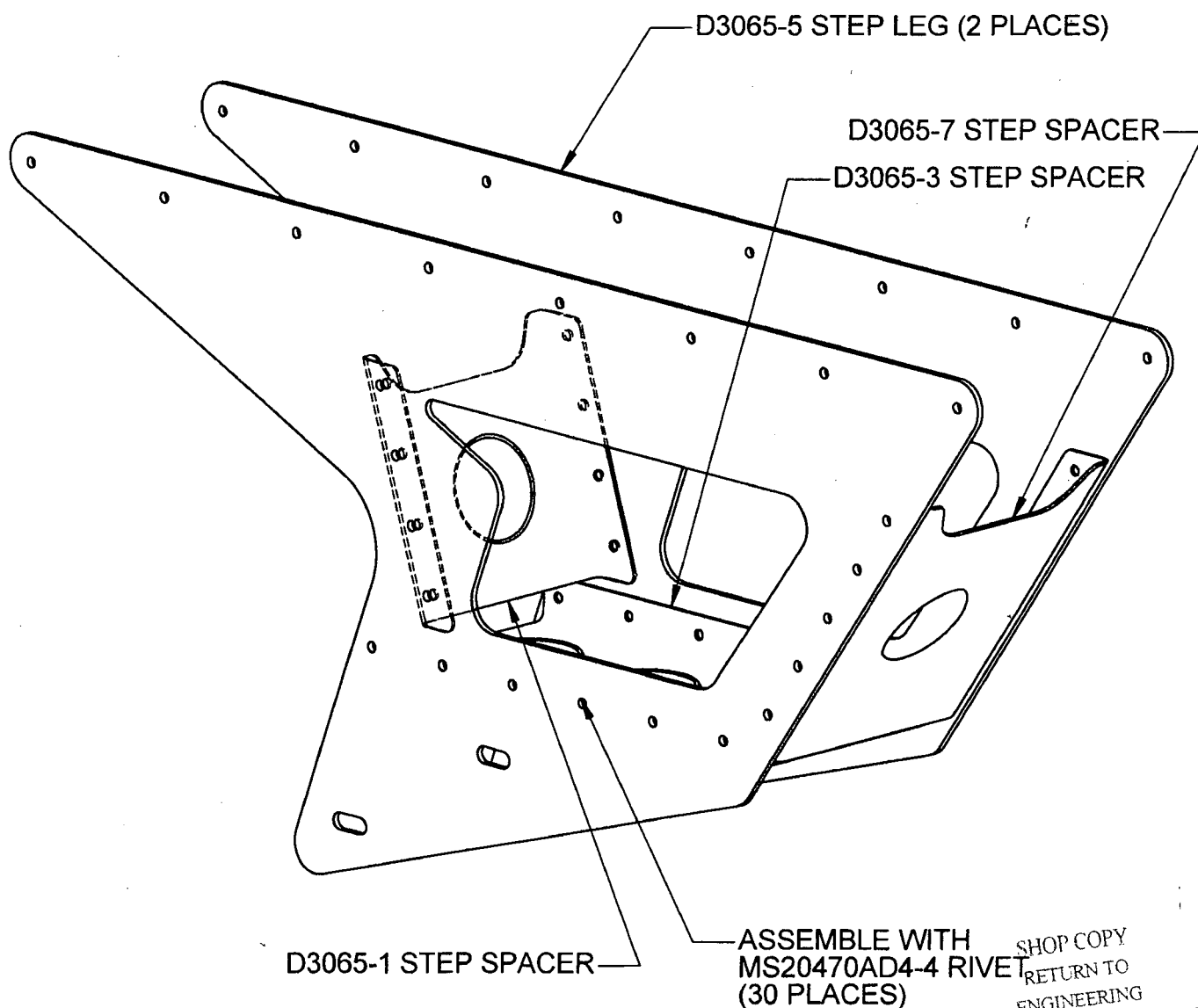
NOTE: Date & initial all entries



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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3065 | REV. B SHEET 1 OF 5 |
| DATE 06.05.23 | | TITLE STEP LEG ASSEMBLY | SCALE 1:2 |
| A | 02.09.11 | NEW ISSUE | |
| B | 06.05.23 | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5 | |

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

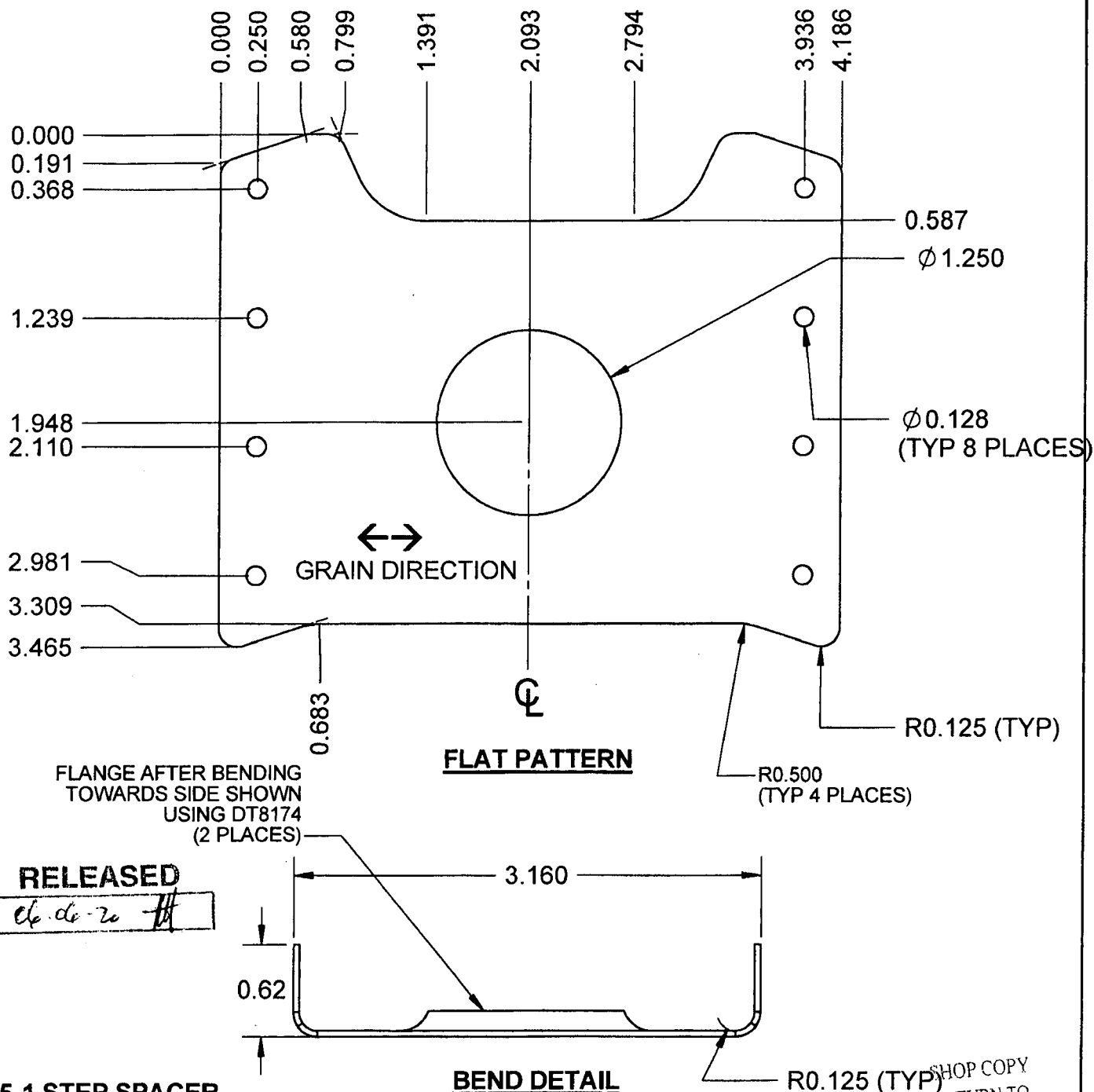
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| DATE 06.05.23 | | TITLE STEP LEG ASSEMBLY | SCALE 1:1 |



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

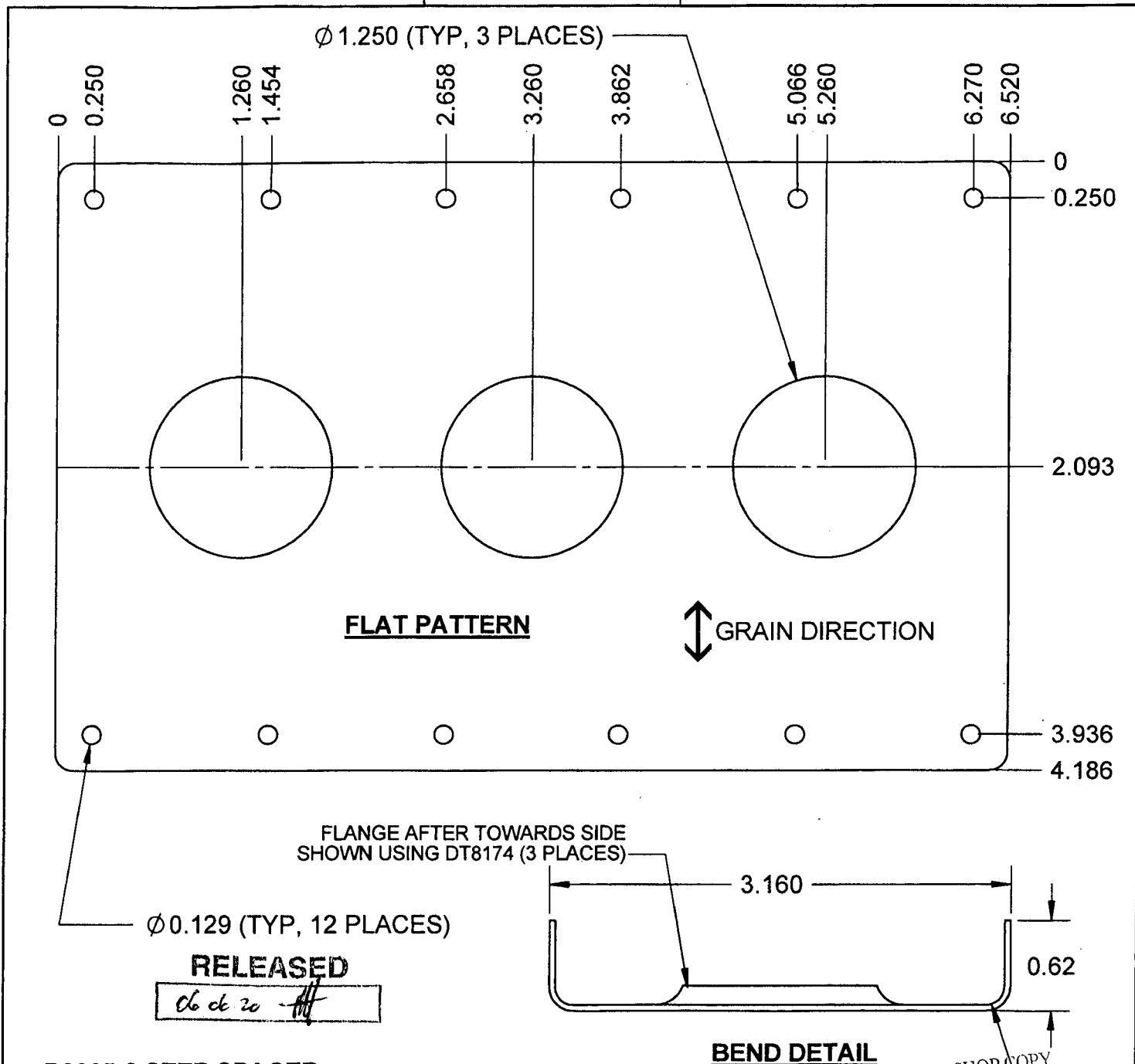
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| DATE 06.05.23 | | TITLE STEP LEG ASSEMBLY | SCALE 1:1 |



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

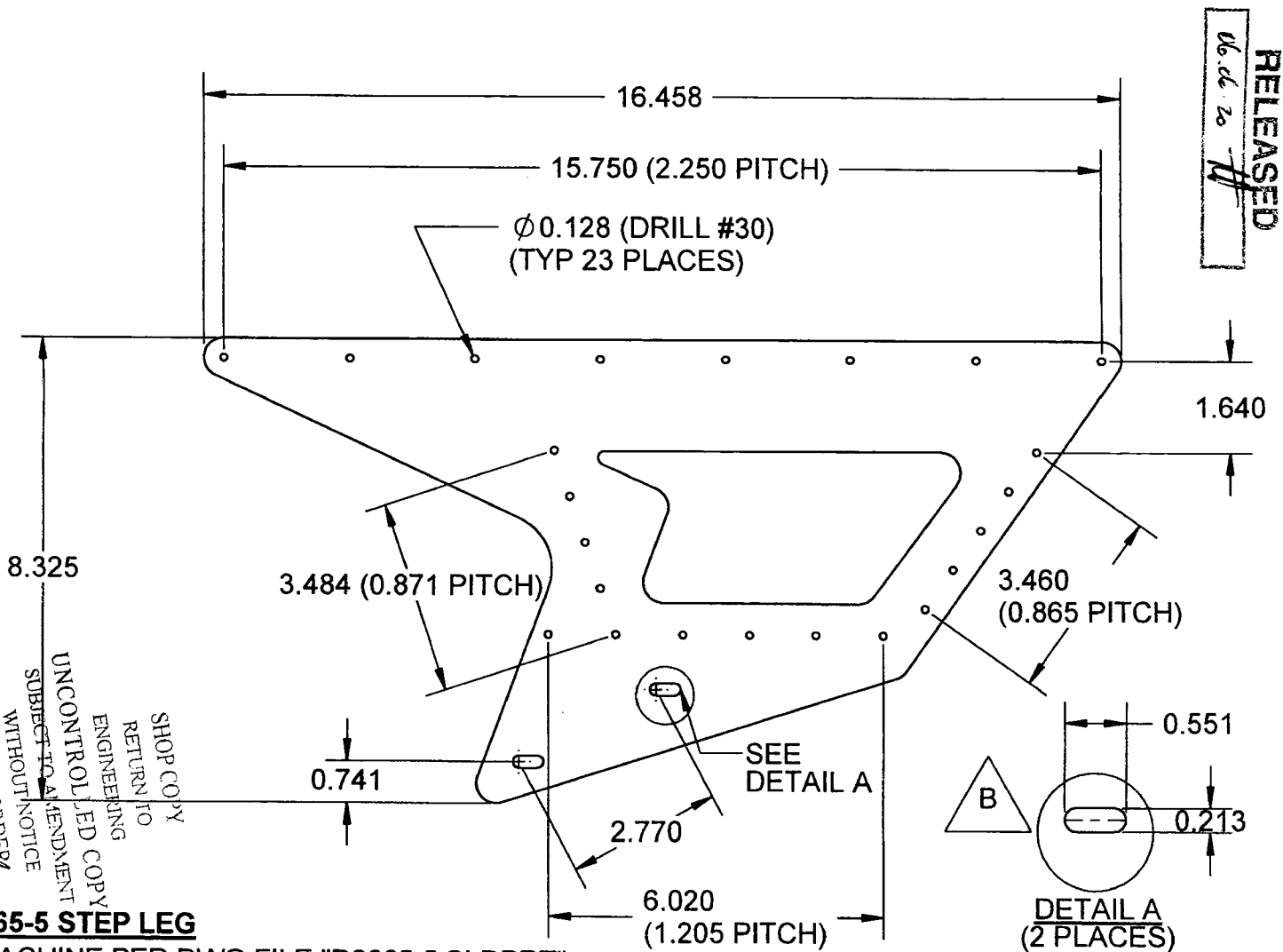
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| CHECKED | APPROVED | DRAWING NO. | REV. B |
| PH | <i>[Signature]</i> | D3065 | SHEET 4 OF 5 |
| DATE | TITLE | | SCALE |
| 06.05.23 | STEP LEG ASSEMBLY | | 1:3 |



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
 (REF DART SPEC M6061T6S.080)
 OR
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

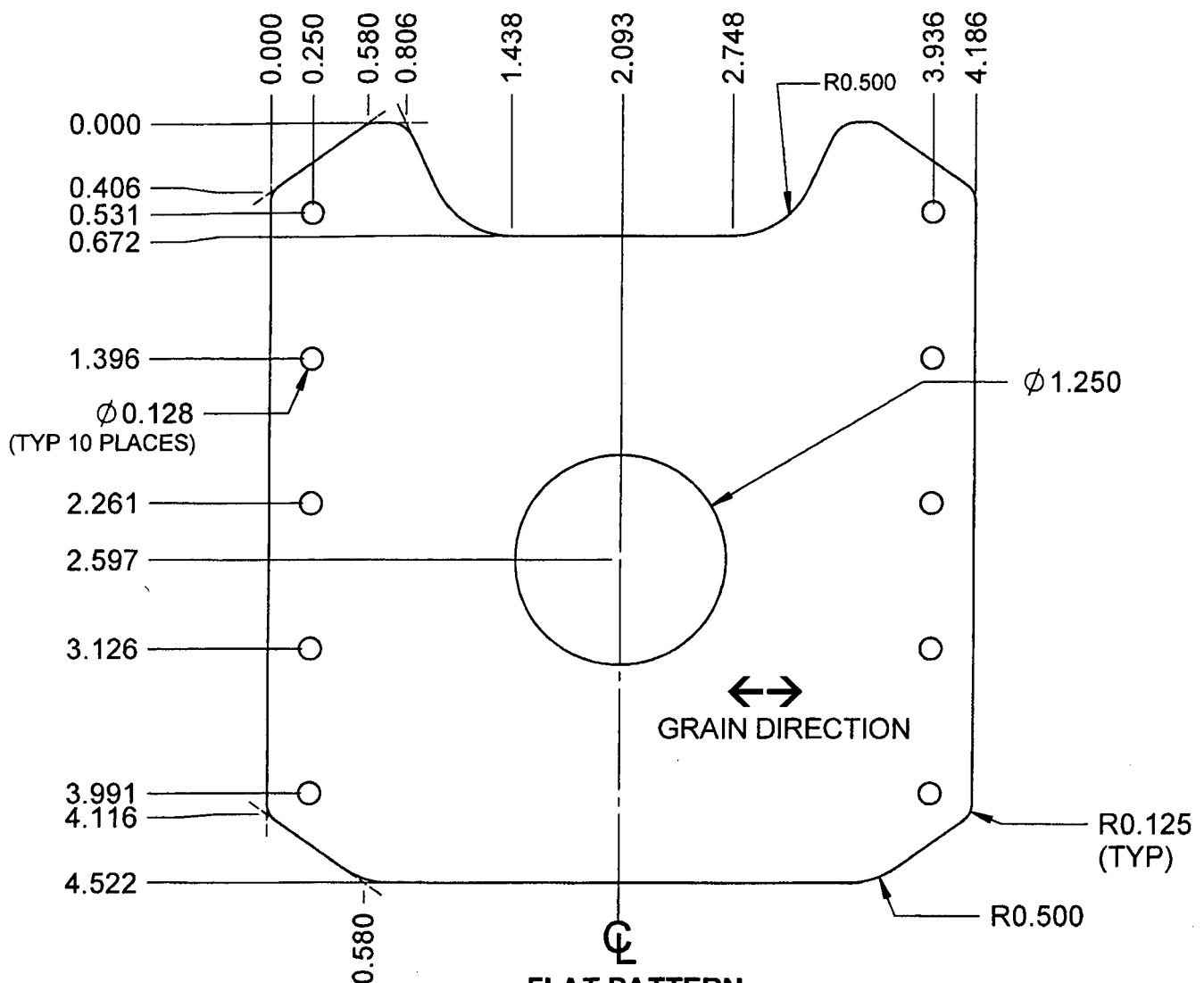
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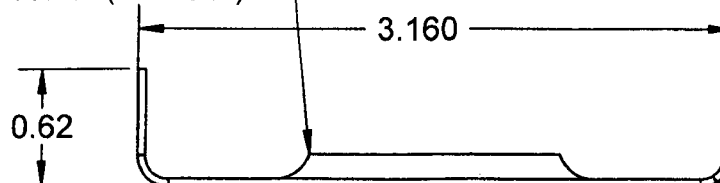
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| DATE 06.05.23 | | TITLE STEP LEG ASSEMBLY | SCALE 1:1 |



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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